

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024023**Date Inspected:** 08-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 022, Located on Bike path Hand rails, FS1-PP53. Welder is identified as 201861. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -Repair.

Repair welding of Weld joint- 013, Located on Bike path Hand rails, FS1-001. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Liu Tao. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) -Repair.

Bay #14

This QA Inspector observed the following work in progress

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### Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 002 as per WRR no. B-WR-20884, Located on U Rib Splice plate X3305-059. Welder is identified as 200569. ZPMC Quality Control Inspector (QC) is identified as Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair.

Repair welding of Weld joint- 001 as per WRR no. B-WR-20884, Located on U Rib Splice plate X3305-003. Welder is identified as 045268. ZPMC Quality Control Inspector (QC) is identified as Li Yan Hua. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair.

### Bay #19

This QA Inspector observed the following work in progress,

### Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint- 061, 026 as per WRR no. B-WR-20945, Located on Cable Bracket components SA6030-001. Welder is identified as 062807. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-Repair.

### Heat Straightening:

Heat Straightening being performed on Cable Bracket s identified as A6032A & SA6532A by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Ping present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 10344.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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## Summary of Conversations:

No relevant Conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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**Inspected By:** Baskar, Govindarajan

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer